

CSF-ANCORS

For corrosion-resistant steel at hydrochloric & sulfuric acid environmental conditions.

AWS A5.29 E71T-GC
JIS Z3313 T49J0T1-1CA-U

Applications

Butt, fillet welding of corrosion-resistant steel at hydrochloric & sulfuric acid environmental conditions such as thermal power plant,

Characteristics

- (1) CSF-ANCORS is a titania type flux cored wire and designed for all-position welding by single pass & multi pass with CO₂ gas shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.

Notes on usage

- (1) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.

Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO₂)

C	Mn	Si	P	S	Cu	Ni	others
0.05	0.90	0.46	0.012	0.010	0.31	0.16	≤0.5

Typical mechanical properties of weld metal

(Shielding Gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J) 0℃
517	591	30.8	82

Size & recommended current range (DC ±)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400
	V-up	120~220	140~260	160~260
	V-down	120~240	140~260	160~280
	OH	120~220	140~260	160~260